

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023402**Date Inspected:** 01-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shen Fu Yoo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath. Math. was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

BAY 14

Deck Panel and Longitudinal Diaphragm

Flux Cored Arc Welding (FCAW) for Deck Panel for weld Joint No. DP-226-001 Joint No. 063, 058, 071, 079, 084, 087, 092, 076, 095 in progress. Welder is identified as 205091. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-Tc-U4b-F.

Flux Cored Arc Welding (FCAW) for Deck Panel for weld Joint No. DP-117-001 Joint No. 052, 057, 060, 065, 073, 076, 09, 15, 20, 024, 029, 031, 033 and 038 in progress. Welder is identified as 207540 and 066422. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-Tc-U5b-F.

Flux Cored Arc Welding (FCAW) Section-6AW Longitudinal Diaphragm Joint No. SEG027F-018 in progress. Welder is identified as 067103. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Flux Cored Arc Welding (FCAW) Section-6AW Longitudinal Diaphragm Joint No. SEG027F-023 in progress. Welder is identified as 067184. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-T-2132

Flux Cored Arc Welding (FCAW) Section-6CW Longitudinal Diaphragm Joint No. SEG031F-022 and 027 in progress. Welder is identified as 067947. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4b-F.

Flux Cored Arc Welding (FCAW) Section-6CW Longitudinal Diaphragm Joint No. SEG031F-014 in progress. Welder is identified as 066401 and 067610. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4b.

Flux cored Arc Welding (FCAW) Deck plate DP168A to DP195A Weld Joint No. SEG033*-004 in progress. Welder is identified as 045260. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the B-T-2231-T.

Submerged Arc Welding (SAW) Deck plate DP168A to DP195A Weld Joint No. SEG033*-004 in progress. Welder is identified as 045265. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

Shielded Metal Arc Welding (SMAW) Section 6BW Weld Joint No CA013. Welder is identified as 045265. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the B-T-2221-B-L2C-S-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
